

Date: Wednesday, 01/10/2008 11:47:33 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: CUP		
Job Number	: 42376			Part Number	: D30093		
Estimate Number	: 13106			Drawing Number	: D3009 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 01/10/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 08/10/2008		
Previous Run	: 41176			Qty:	500	Um:	Each
Written By	:						
Checked & Approved By	: <u>MNF 08-10-01</u>						
Comment	: Est. A 07.12.18 new issue EC Est Rev:B 08-01-08 ECN 1089 rev:b as per dwg DD verified by:ec						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304R1000	304 round bar 1.00	
<p>Comment: Qty.: 0.0503 f(s)/Unit Total : 25.1475 f(s) 304/316 SS ROUND BAR Material: AISI304/316 SS 1.00" Ø Round Bar (M304R1000) Batch: <u>M109508</u> : <u>MNF 08/10/11</u></p>			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
<p>Comment: 1-TURN AS PER FOLIO FA130 & DWG D3009 FOLIO REV: <u>A</u> DWG REV: <u>B</u></p> <p>2-DEBURR AS REQUIRED</p> <p><u>MNF 08/10/11</u> </p>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p> <p><u>MNF 08/10/11</u> </p>			
4.0	QC8	SECOND CHECK	
<p>Comment: SECOND CHECK</p> <p><u>DIP 08/10/11</u> </p>			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
<p>Comment: PACKAGING RESOURCE #1</p> <p>Identify and Stock Location: <u>SG</u> <u>8/10/14</u> </p>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUP

Job Number: 42376

Part Number: D30093

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/15 *MF*

Job Completion



MF 08-10-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	42376
Description: Cup	Part Number:	D3009-3
Inspection Dwg: D3009	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: 	Audited by: 	Prototype Approval: <input checked="" type="checkbox"/> Date: N/A
Date: 08/10/06	Date: 08/10/11	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.01.22	New Issue	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

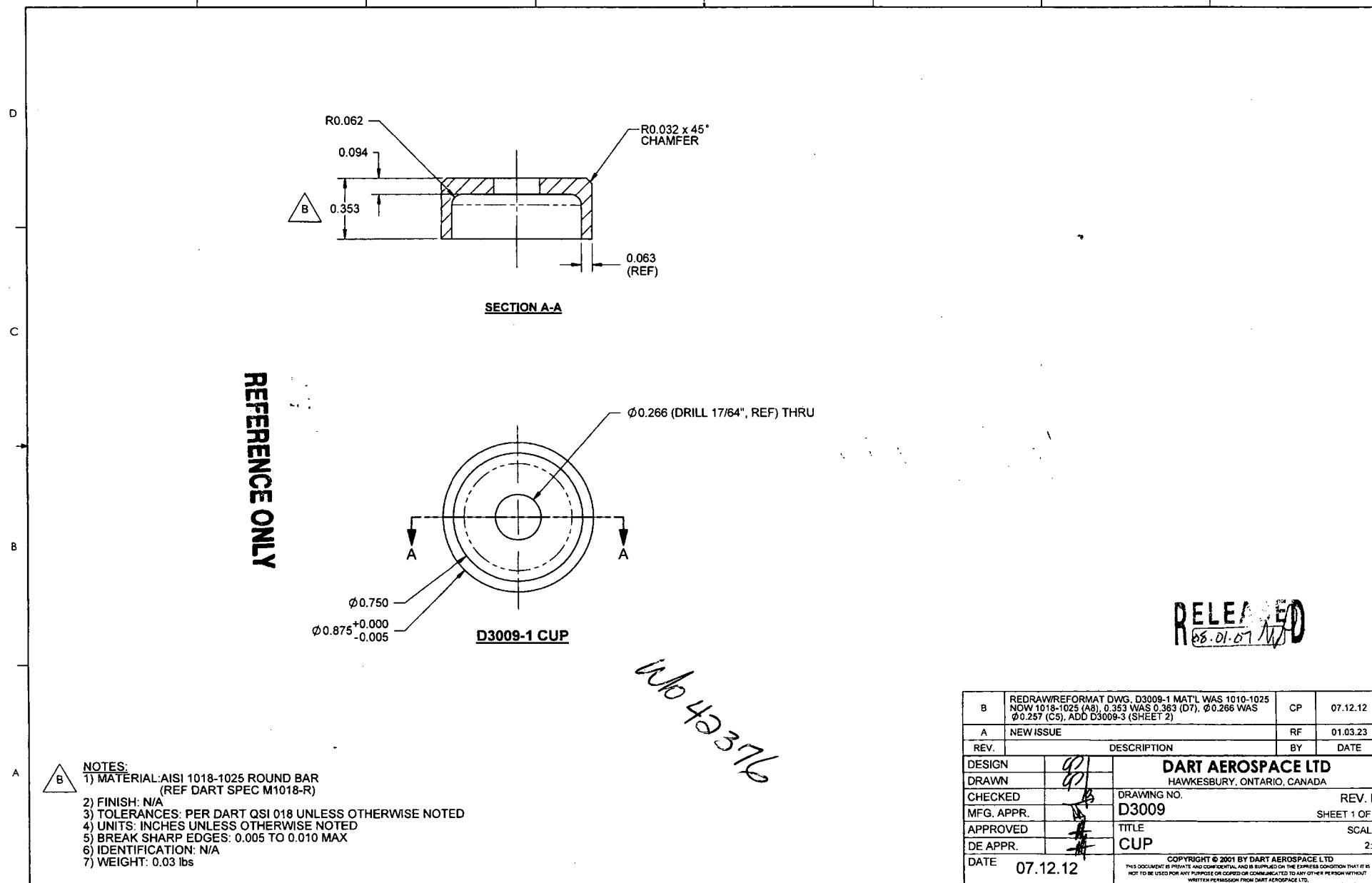
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

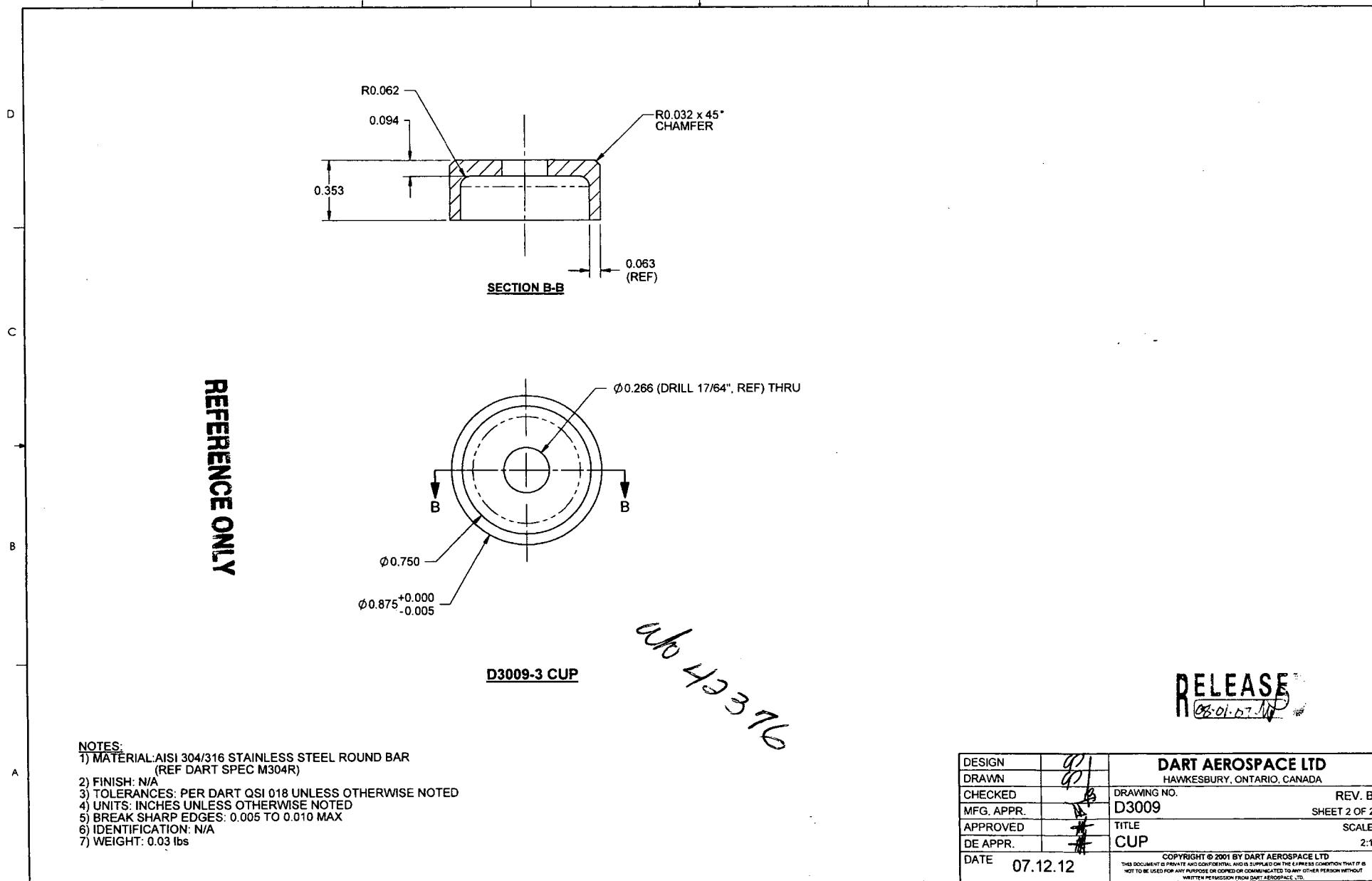
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

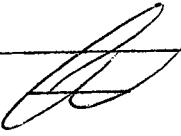
Date: 8/10/08Batch No: M109508Supplier: MAGNADart P/O: 7287

Packing Slip: Yes No
 Invoice: Yes No
 Receipt: Cash Cr

Release Note Attached: Yes No N/A
 Waybill Attached: Yes No N/A
 Shipment Complete: Yes No N/A
 QC6 Inspection:
 Work Order:

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 

Production/Admin:

Date 08/10/08Received/Costing KCY 9108Initials CGLocation

H:\FORMS\Purchasing\approved purch\RECREPORT Rev.D

RECEIVED OCT 16 2008

10/09/08 14:54:04

Merchandise:	710.00
Surcharges:	25.00
No Tax Costs:	
GST	36.75
Total Due:	771.75

Title to the goods sent out on this invoice remains with Magna Stainless until such time as this invoice has been paid in full. Unless otherwise noted terms are 30 days. Interest accrues on all overdue accounts at the rate of 1.5% per month compounded monthly.

Q.S.T. # 1213236471

G.S.T. # 881565899 RT0001

space Ltd
Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613) 632-3336
Fax: (613) 632-4443

Oct 6, 2008

Receipt Number
RCP00009108

Purchase From:

Magna Stainless
525 avenue Meloche
Dorval, QC H9P 2W2
Canada

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-MAG002	PO00007287

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M303R0500	303 Round Bar 0.500" (NOTE: AISI 304/316 NOT ACCEPTABLE) MATERIAL: AISI 303 ROUND BAR B/N109508	48.0333 f		2.450000	117.68	Oct 06, 2008
	M304R1000	304 round bar 1.00 (NOTE: AISI 303 NOT ACCEPTABLE) MATERIAL: AISI 304/316 ROUND BAR B/N109508	75.0000 f		8.500000	637.50	Oct 06, 2008

Comments:

SOLD TO:
 DART AEROSPACE LTD
 1270 ABERDEEN STREET

HAWKESBURY , ON
 K6A 1K7
 Contact: CHANTAL

SHIP TO:
 DART AEROSPACE LTD
 1270 ABERDEEN STREET

HAWKESBURY , ON
 K6A 1K7

Ship Terms: PREPAID

SPECIAL INSTRUCTIONS
 STOCK

MTR: Y

Currency	Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS	ERYCK BLAIS	(613) 632-5200	(613) 632-1053	7287	
Sales Order	Terms	Ship Via	Date Ordered	Date Required	Date Shipp
W001398	NET 30 DAYS	TARGET	10/02/08	10/03/08	10/03/08

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
4		PC	STAINLESS ROUNDS SRB 303 1/2" x R/L	12'1"	32 LB / 4 PC	L009029 14523 4
6		PC	SRB 304 1" x R/L	12'5"	202 LB / 6 PC	L015199 419280 6
			FUEL SURCHARGE			

Bundles: 1

Total Weight: 234 LB

Received by: _____ Date: _____ Signature: _____

Acciaierie Valbruna S.p.A.



CERTIFICATO DI COLLAUDO ABNAHMEPRUEFZEUGNIS INSPECTION CERTIFICATE CERTIFICAT DE RECEPTION EN 10204, 3.1

36100 VICENZA (Italia) - Viale della scienza, 25 z.i.
Stab.: 39100 BOLZANO (Italia) - Via A. Volta, 4
Cliente / Besteller/Purchaser/Client
VALBRUNA CANADA LTD
8724 HOLGATE CRESCENT
CDN-MILTON, ONT L5T 5Z1-CAN

Produttore: ACCIAIERIE VALBRUNA S.P.A.
Hersteller/Item/Usine produtrice

Oggetto Prove: - Annealed Cold Drawn
Prüfgegenstand/Item Inspected/Finissage

Avviso di Spedizione: D-VI07007544
Lieferanzeige/Packing list/B.L.

Ordine nr: 702001762 STOCK
Bestell/Your order/Commande

Certificato nr: MEST466400/2007/
Prüfung/Test/Essai

Conferma ordine nr: EI07001200
Werks/Our Order/Ref nr.

Marchio di Fabbrica:
Zeichen des Lieferwerkes
Trade mark
Signe de l'usine produtrice



Punzone del Collaudatore:
Stempel des Werkssachverständigen
Inspector's stamp/Pointon de l'assayeur

Specifiche: Anforderungen / Requirements / Exigences

VAL CANADA 2 304/304L A,CF
ASME SA182 2004 S30400/03 o
ASME SA479 2004 S30400/03 o
ASTM A262 2002A PRACTICE E
ASTM A320 2005A B8
NACE MR0175* 2003 S30400/03 A 5
(0) SEC.II PT.A 2004 EDITION ADD.2006
(1) SEC.II PT.A 2004 EDITION ADD.2006
(3) SEC.II PT.A 2004 EDITION ADD.2006
(5) * ISO 15156-3

AMS 5639 H S30400
ASME SA193 2004 B8 1
ASTM A182 2006 S30400/03 4
ASTM A276 2006 S30400/03
ASTM A479 2006 S30400/03
QQ-S-763 F 304/304L

AMS 5647 H S30403
ASME SA320 2004 B8 (2)
ASTM A193 2006A B8
ASTM A314 97 S30400/03
MIL-S-862 B/1 304/304L

0Chemical analysis only.
2SEC.II PT.A 2004 EDITION ADD.2006
4Chemical analysis only.

Qualità: T-304L
Werkstoff/Grade/Nuance

Marca: MVAISL MAXIVAL
Markenbezeichnung/Brand/Nuance

Pos. nr. Pos. nr. Item nr. Nr. de poste	Objetto Gegenstand Product description Descrip. du produit	Dimensioni - In Abmessungen Dimension Dimension	Tolleranza Toleranz Allowance Tolerance	Lunghezza - Ft Länge Length Longueur	Colata Schmelze Heat Coulée	Pezzi Stückzahl Pieces Pièces	Peso - LB Gewicht Weight Poids	Lotto nr. Losnr. Lot nr. Lot nr.
0030	Round	1,0000	484-05A	12 / 12	419280		18.116	703905280

Sono state soddisfatte tutte le condizioni richieste
Die gestellten Anforderungen sind erfüllt.
The material has been furnished in accordance with the requirements
Le matériels a été trouvé conforme aux exigences

Punzonatura: T-304L
Kennzeichnung/Marquage/

TEST	Prova/Probessub Specimen/Prüfprobe Längsdiam. Spess. Breite Diam. Dicke Width Diam. Thickness Lang. diam. epaisse mm	°F Posiz. Saggio Position Locality Emplacement	Sfornamento Streckgrenze Yield Stress Limite élastique Rp 0,2% k.s.i.	Sfornamento Streckgrenze Yield Stress Limite élastique	Resistenza Zugfestigkeit Tensile strength Résistance à traction Rm k.s.i.	Allungamento Elongation Elongation Allongement	Strizione Einschleifung Reduction of area Schröpfung RA %	Resilienza Korbschlagarbeit Impact Value Résilience	Durezza Härte Hardness Dureté HB 1/2 r.
A	12,5	68 L	72		99	45	67		220

1) L=longitudinale/längs, Q=trasversale/quer, T=Tangenziale/tangential

Grain size for ASTM E112 : 5

Analisi chimica

Chemische Zusammensetzung/Chemical Analysis/Analyse chimique

Colata /Heat Schmelze/Coulée	min - max 0,030	1,00	2,00	18,00 20,00	1,00	1,00	8,00 10,50	-	0,040	0,030	0,100	-	-	-
419280	C %	Si %	Mn %	Cr %	Mo %	Cu %	Ni %	Co %	P %	S %	N %			
	0,018	0,57	1,79	18,07	0,46	0,72	8,15	0,076	0,026	0,027	0,096			

Produced without class I-II Ozone depleting substances.

Solution heat treated free from continuous carbide network.

Annealing temperature: 1960°F for 1 H/H₂O.

Micro and macro etch test: OK

Intergranular corrosion test per ASTM A262 pract. E: ok.

Material is DFARS Compliant

Melted and manufactured in Italy No welding or weld repair Material free from Mercury or radio-activity contamination
The Quality Management System is Certified acc. Pressure Equipment Directive [97/23/EC] Annex 1, s., 4.3 by TUEV and LLOYD'S

Vicenza, 09/03/07
JCQ008
(Mod. MCER)

Il collaudatore di stabilimento / der Werkssachverständige / Works inspector / L'agent d'usine

M. Rizzotto

Pagina - 1 di 1